

Date: Tuesday, 9/26/2006 2:42:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X16")
Job Number	: 28730		
Estimate Number	: 10320		
P.O. Number	: N/A	Part Number	: K10007
This Issue	: 9/26/2006 S.O. No. : N/A	Drawing Number	: D2435 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 28343	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/3/2006
Checked & Approved By	: <u>[Signature] 06.09.26</u>	Qty:	13 Um: Each
Comment	: Est Rev: C 04.02.17 Blank size changed KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile: K10007

D206-559

D500-572

D120-638

D058-678

and create labels per PPP K10005 CHG003

(Bag Bluefiles separately)

KS 06-09-27 (13)

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.5491 sf(s)/Unit Total: 54.5895 sf(s)
 blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: 3162164 X 26

En 06/09/27 x 26 (13)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

J.F. / En 06/09/27 26 (13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:42:49 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 28730

Part Number: K10007

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP / 60 d107127 /

26(13)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06.09.29

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total : 19.9920 f(s)

Pick: Packing Kit

20.65

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion

28042

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

328344

2 D2435(ref only) Bearpaw

228730

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438

Clamp

328345

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:42:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 28730

Part Number: K10007

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : ¹⁰⁴96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 D2529

Washer B27876 ✓

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : ¹⁰⁴96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN4-15A

Bolt

M122039 ✓

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : ¹⁰⁴96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN4-17A

Bolt

M101124 ✓

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : ²⁰⁸~~192~~.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 16 AN960JD416

Washer

M19185 ✓

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : ¹⁰⁴~~96~~.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 MS21042L4

Nut (or -4)

M19099 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DE Date: 06/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:42:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 28730

Part Number: K10007

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S Clamp M10 2296

1 Paperwork package

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPk10007

Location:

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U Del. 10/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	28730
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓			
B 5.500	+/-0.030	5.497	✓			
C 0.200	+/-0.030	0.195	✓			
D R0.250	+/-0.030	0.250	✓			
E 0.250	+/-0.010	0.258	✓			
F 0.625	+/-0.030	0.628	✓			
G 0.25 x 45°	+/-0.030	0.23 x 45°	✓			
H 0.375	+/-0.010	0.378	✓			
I 19.000	+/-0.030	19.00	✓			
J 0.950	+0.030/-0.010	0.951	✓			
K Ø0.260	+0.005/-0.000	0.260	✓			
L Ø0.930	+/-0.030	0.932	✓			
M 0.30	+0.030/-0.000	0.323	✓			
N 0.375	+/-0.030	0.372	✓			
O 7.375	+/-0.030	7.371	✓			
P 4.250	+/-0.010	4.249	✓			
Q 2.000	+/-0.030	1.997	✓			
R 9.000	+/-0.010	9.008	✓			
S 15.750	+/-0.030	15.75	✓			

Measured by: <i>Ed</i>	Audited by: <i>amf</i>	Prototype Approval:	N/A
Date: 06/07/27	Date: 06/07/27	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

DART

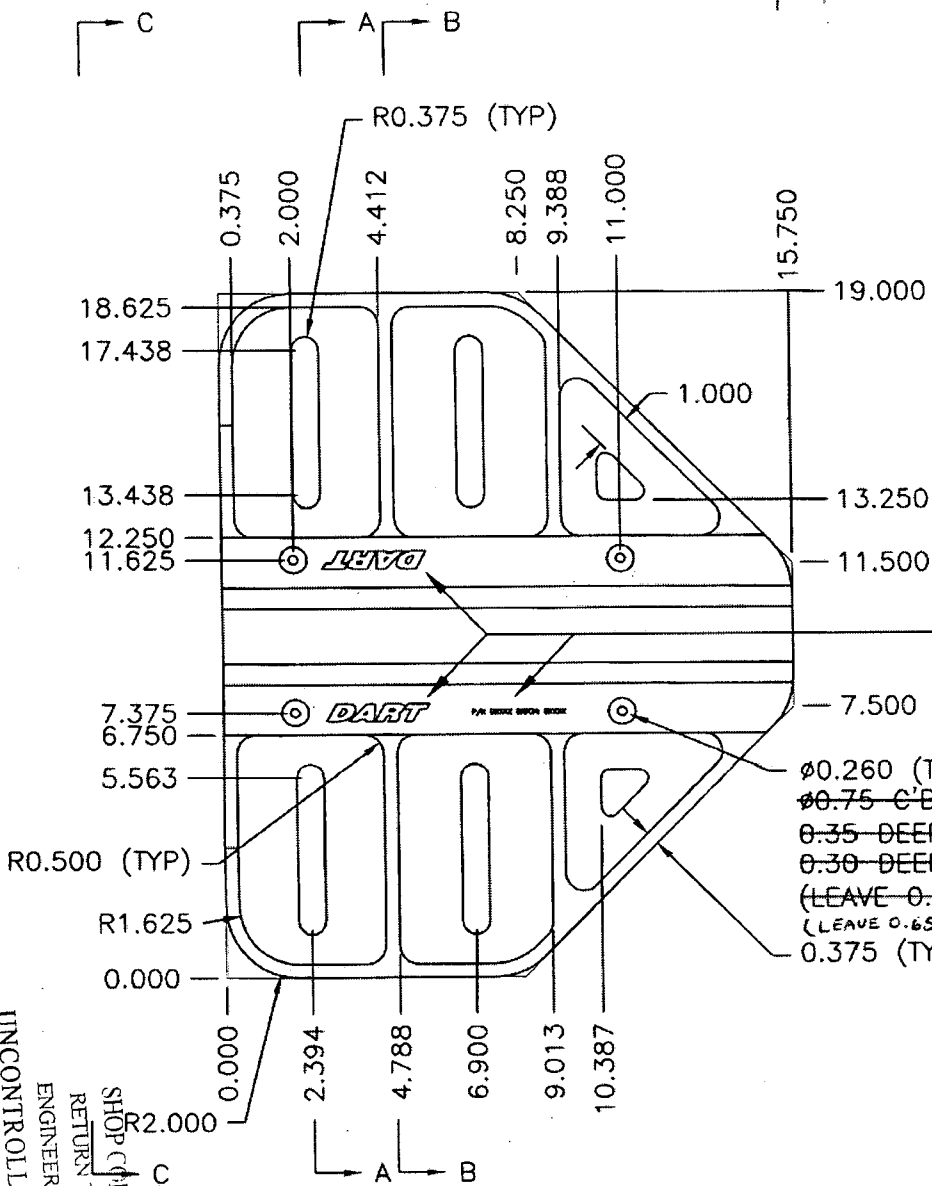


RELEASED
93.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	

A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



$\phi 0.260$ (TYP) $\phi 0.93$ C'BORE
 ~~$\phi 0.75$ C'BORE~~ 0.30 DEEP FROM BOTTOM
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM
 (LEAVE 0.300 MIN.)
 (LEAVE 0.650 MIN.)
 0.375 (TYP)

9143

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

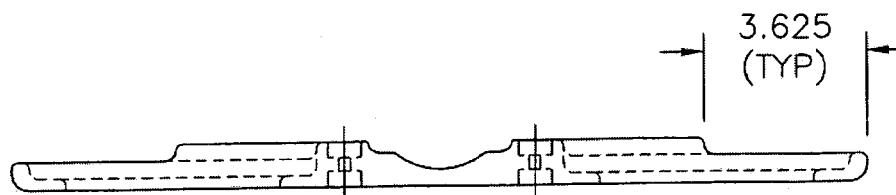
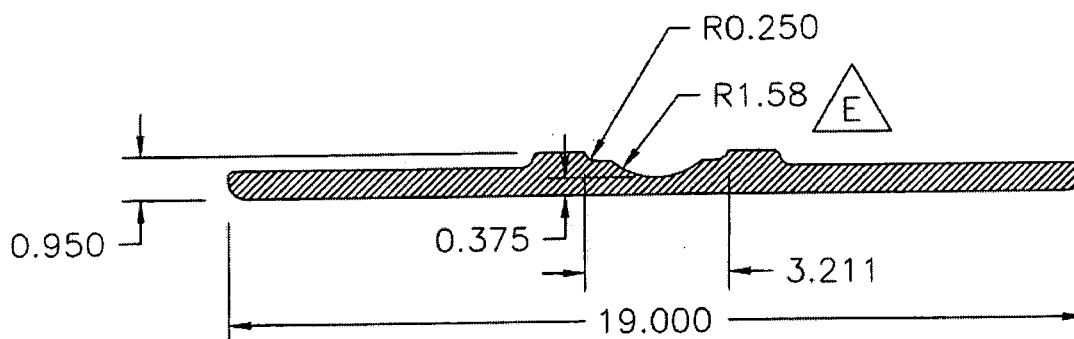
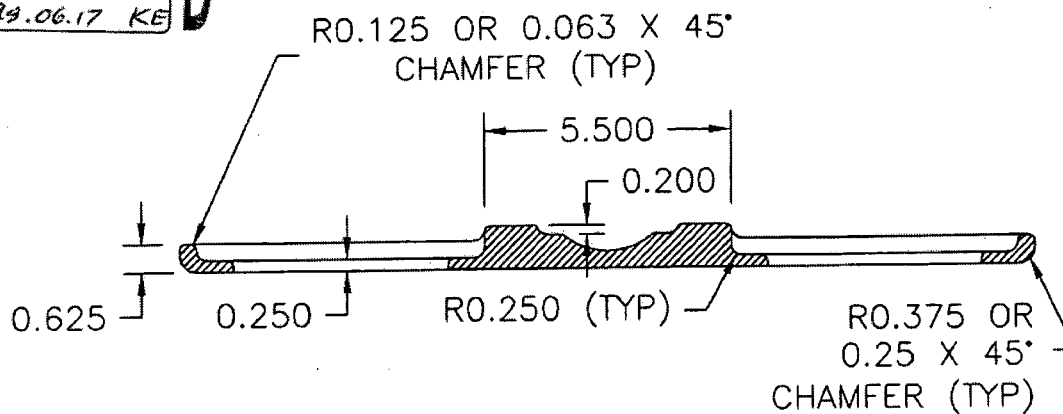
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 RETURN TO



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DJB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



SECTION C-C

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